

# Work Order ID 51599

August 27, 2009 8:25:27 AM



Page 1

Item ID: D3277-1

Revision ID: A

Item Name: Window

Start Date: 8/27/09 Start Qty: 2.00

Required Date: 9/11/09 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: *MP*

Date: *08-27*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3277

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3277  
Deburr if necessary

Dwg Rev: A

Prog Rev: A 2-

HB 9-9-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-9-23

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 8/29/09/24

(Y2) 4

(P10) ->

W/O: 51599

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/9/24		Perm. change ADD step to engine P/N + B#	EB	09/09/24	(2)		S 09/09/24
				09/09/25			

Part No: D3277-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Work Order ID 51599

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Page 2

Item ID: D3277-1

Revision ID: A

Item Name: Window

Start Date: 8/27/09 Start Qty: 2.00

Required Date: 9/11/09 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

27 8/27/09/24

(+2)

0

140



Packaging

Packaging

Identify as per dwg & Stock Location. 209

0.00

Memo

0.00

9/9/24 (24) SP

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/25 \*J  
MF 09-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 27, 2009 8:25:27 AM

Page 1

Work Order ID: 51599

Parent Item: D3277-1RevA

Parent Item Name: Window

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	147.2142	10.8926			



1/8" Polycast II Sheet



184-9-03

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

147.2142

110115

4

110633

72

111711

71.2142

110633

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

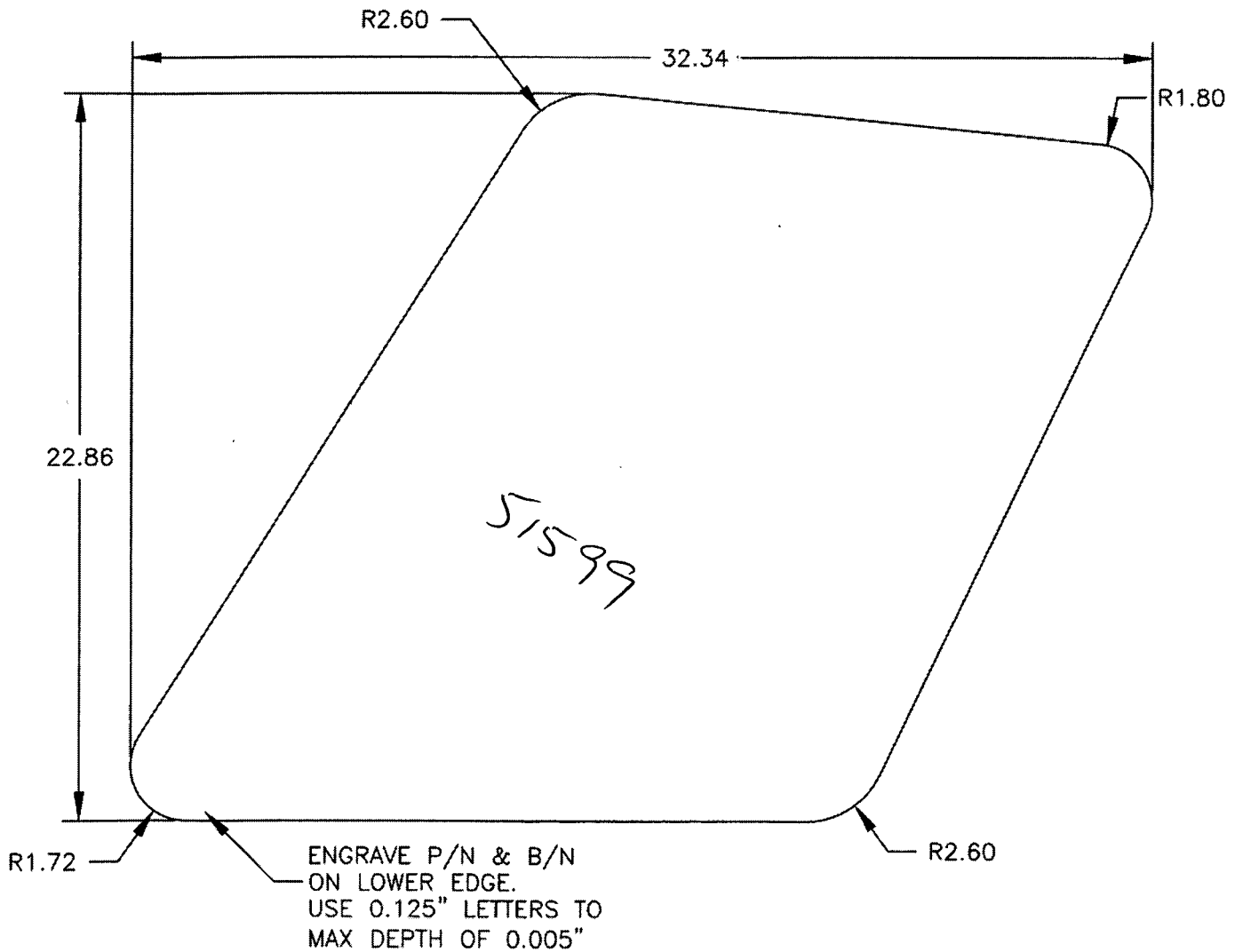
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3277	REV. A SHEET 1 OF 1
DATE 04.08.23		TITLE CREW WINDOW (R44)	SCALE 1:5
A	04.08.23	NEW ISSUE	

**RELEASED**  
05 03 18 *[Signature]***D3277-1 WINDOW**

- 1) CUT PER TEMPLATE D3277-1T1
- 2) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.125 THICK  
(REF DART SPEC. M-ACRYLIC-S.125)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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